

639



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

5857

D212-664-101
Job Sheet 182866



Part No: D212-664-101

Job Qty: 1 ea

Part Name: Fwd Crosstube - High



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/5/18

Job Tracking No:

Due Date: 9/26/18

Created By: Jesse White

Type: SOLD

Description:

Note: D212-664-141 REV E/ IIN-D212-664 REV.J IPP Rev:E 04.02.16 Reformat KJ/DS IPP Rev:F 06-03-29 Remove
Comments on Pick List JLM IPP Rev:G 07-04-30 As per Rev C JLM IPP Rev:H 11.04.26 inspection strip ecn 11-
549 EC verf by:DD IPP REV:I 14.05.27 AS PER ECN 14-570 DD VERF:JLM

Ship Via:

Bill of Materials



Container No: S110095



Part: D212-664-101

Job No: 182866

Serial No/Batch: S110095

Revision: E/J

Inspector:

Exp Date:

Instructions: TC STC SH01-9 Issue 3, FAA STC SR01298N

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		9/26/18	0.00	0.00	Start Up Stores/Pkg-1		GP 2018-09-14
110	Packaging	1 pcs		9/26/18	0.00	0.00	Packaging1-3		GP 2018-09-14
120	CNC Bend Crosstubes	1 pcs		9/26/18	3.11	2.22	CNC Bend Crosstube		GP 2018-09-14
130	QC	1 pcs		9/26/18	0.00	0.00	QC15		38
140	Crosstubes	1 pcs		9/26/18	0.00	0.67	Crosstubes-1		GP 2018-09-14
150	HandFXtube	1 pcs		9/26/18	0.00	0.98	HandFinish5		GP 2018-09-14
160	QC	1 pcs		9/26/18	0.00	0.00	QC7-1		38 DAS
165	QC	1 pcs		9/26/18	0.00	0.00	QC5		9-89 38
170	Outsource	1 pcs		9/26/18			SKY002-VC		OCT 0 1 2018
180	Packaging	1 pcs		9/26/18	0.00	0.00	Packaging2		OCT 0 2 2018
190	QC	1 pcs		9/26/18	0.00	0.00	QC5		38
200	SprayPaint	1 pcs		9/26/18	0.00	0.25	Spray Paint		SEP 27 2018
210	QC	1 pcs		9/26/18	0.00	0.00	QC14		38
220	Crosstubes	1 pcs		9/26/18	0.00	1.69	Crosstubes-1		OCT 0 2 2018
230	QC	1 pcs		9/26/18	0.00	0.00	QC5		38
240	Packaging	1 pcs		9/26/18	0.00	0.00	Packaging1-3		DAS OCT 1 2018
250	QC	1 pcs		9/26/18	0.00	0.00	QC4		DAS OCT 1 2 2018
260	Packaging	1 pcs		9/26/18	0.00	0.00	Packaging3-1		BB 69 OCT 1 2 2018
265	DC	1 pcs		9/26/18	0.00	0.00	DC		18-10-12
270	QC21-FG	1 Ea		9/26/18	0.00	0.00	QC21		18-10-12

Part Op 120 - Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio D212-664-101

Descriptions: 140 - "1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549, using drill table DT8577, set-up towers in hole #7 as per QSI 10 2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141 4-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141"

150 - ***IMMEDIATELY AFTER GRINDING***

170 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

180 - Ensure copy of NDT results attached to work order.

190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D212-664-141

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Prime inside & outside crosstube as per QSI 005 4.2 BATCH: 138872 2- After painting remove masking and apply matte clear coat per QSI005 4.2 3- MASK UNDERSIDE OF CROSSTUBE AS SHOWN ON DWG BEFORE PAINTING 4 -Paint Outside of Tube as per Dart QSI 005 4.2 clear 138832 Paint 138949

210 - Then, Wrap in plastic bag to protect from scratches

220 - *****LAY DOWN CROSSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, USE HOLE IN TAPE MEASURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** 1- Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with

Proseal 890 per D212-664-141 and QSI 015 A/R Proseal 890 Batch: 5096394 EXP: 3/19

PROSEAL CURE TIME 72 HOURS: Start: 18-10-2 Finish: 18-10-5 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) using DT9565 as per Dwg D212-664-141. ***Torque all clamps to 80-100 IN-LBS.***

230 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***

250 - ***VERIFY BY BATCH # TO MATCH W/O

260 - Identify and pack for shipping as per PPP D212-664-101 Location : FG094

265 - Photocopy bluefile and create labels as per PPP D212-664-101 CHG006

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D212-664-101TRN	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	
D2893-1	Support	2 Ea (2 ea)	220-Crosstubes	
D3595-063-450	Rubber Cushion 0.63" Wide X 4.50" Long	4 Ea (4 ea)	220-Crosstubes	
MS21920-25	Clamp	4 Ea (4 ea)	220-Crosstubes	
AN6-35A	Bolt	4 Ea (4 ea)	240-Packaging	5094506x3 5.1 4898X1
AN6-36A	Bolt	4 Ea (4 ea)	240-Packaging	5098035
D3428-1	Placard	1 Ea (1 ea)	240-Packaging	5046306
MS21042L6	Nut	6 Ea (6 ea)	240-Packaging	5083542
NAS1149D0663J	Washer	18 Ea (18 ea)	240-Packaging	5093800

Job Allocations

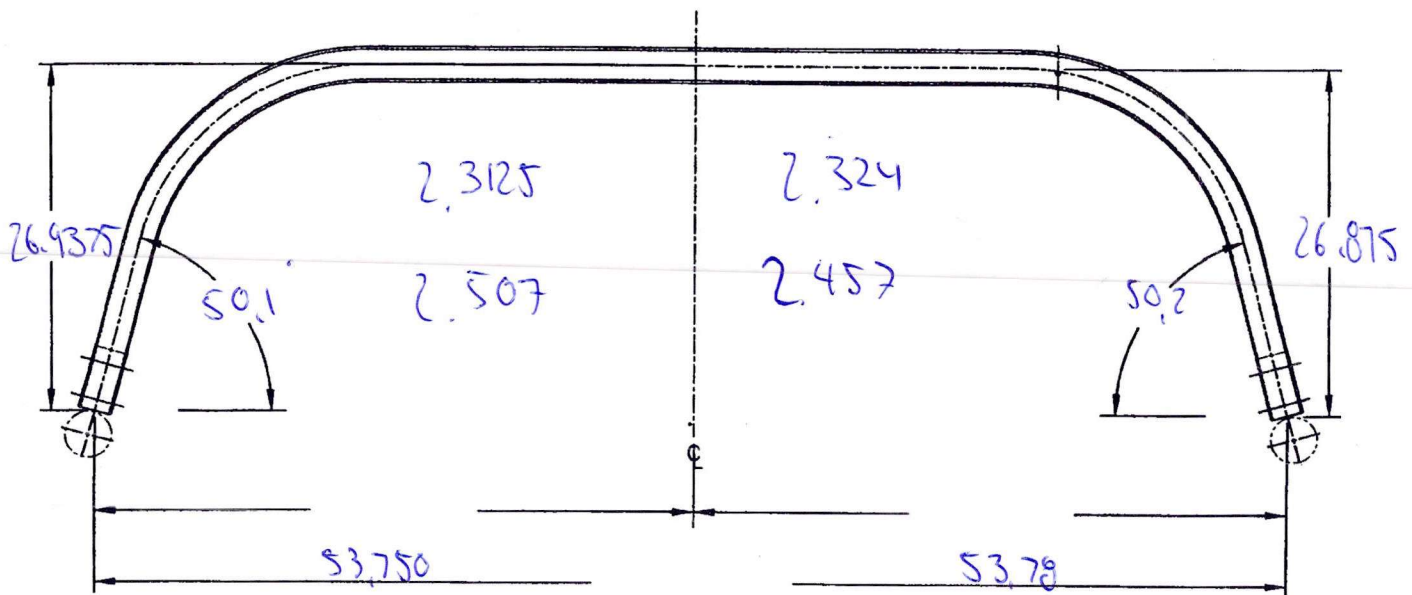
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D212-664-101TRN	1	5	0
220-Crosstubes	D2893-1 5109395	2	9	0
	D3595-063-450 5078312	4	90	0
	MS21920-25 507731	4	192	0
240-Packaging	AN6-35A	4	79	0
	AN6-36A	4	117	0
	D3428-1	1	28	0
	MS21042L6	6	466	0
	NAS1149D0663J	18	1,344	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order:	
Description: Crosstube High Fwd (205/212/412)		Part Number:	D212-664-101
Inspection Dwg: D212-664-141 Rev: E			Page 1 of 1

Required Dimension	Min	Max
Height	26.67	27.17
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7
Bending Passes	3	--
Crushing	--	7.2%



	Side A	Side B
Bending Passes	6	4
Crushing	4	2.8
Comments		

QC15 Inspection	PB
Date	18-09-13

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	
C	10.04.01	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	
E	14.07.28	Revised max crushing %	KJ	
F	16.01.15	Revised Height min/max dimensions	KJ	up

Item	Qty -141	Qty -141B	Qty -141F	Part Number	Description
1	X			D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X		D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3			X	D212-664-141F	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD) (ANODIZED)
4	1	1	1	D6005-128	CROSSTUBE
5	2		2	D2893-1	SUPPORT
6	4	4	4	D3595-063-450	RUBBER CUSHION
7		2		D5017-1	SUPPORT
8	4	4	4	MS21920-25	CLAMP (OR MS21920-26)
9	A/R	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- FINISH -141 & -141B: a) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
b) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
c) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)
d) PAINT OUTSIDE PER DART QSI 005 4.2
e) REMOVE MASKING AND APPLY MATTE CLEAR COAT
FINISH -141F: a) ANODIZE PER MIL-A-8625, TYPE II, CLASS 1.
b) ALODINE (DO NOT ETCH) PER QSI 005 4.1.2
c) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
d) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)
e) PAINT OUTSIDE PER DART QSI 005 4.2
f) REMOVE MASKING AND APPLY MATTE CLEAR COAT
***NOTE:** BETWEEN FINISHING OPERATIONS EXTREME CARE MUST BE TAKEN NOT TO CONTAMINATE OR DAMAGE FINISHED SURFACES.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS
- WEIGHT: D212-664-141/-141B/-141F = 33.6 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

MACHINING

- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.

BENDING

- BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7.2% (BASED ON O.D.) IN LOWER HALF OF R35.5 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

ASSEMBLY

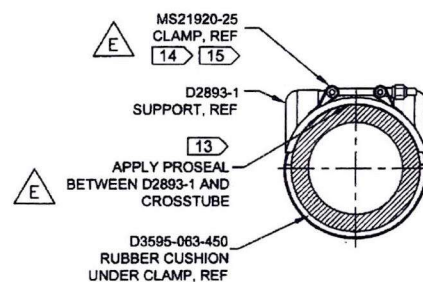
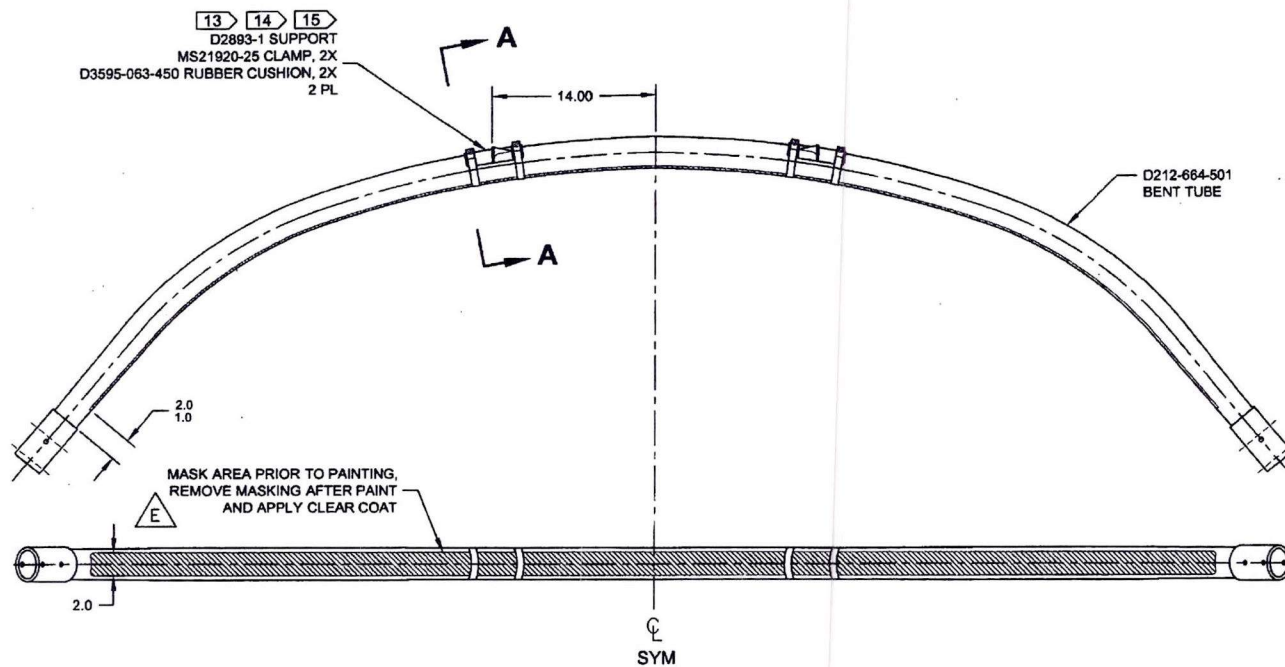
- TO INSTALL D2893-1 / D5017-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP SIDE OF CROSSTUBE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

RELEASED
2014-05-26
WD

E	ADD -141F. D5017-1 WAS D2893-1 (-141B), PROSEAL WAS MAGNOBOND, NOTE 2: ADD INSPECTION WINDOW, NOTE 11: ALLOW 7.2% CRUSH, NOTE 15: ADD 72HR CURE AND RETORQUE FOR PROSEAL, ADD SHEET 3, CLAMPS REVERSED TO PREVENT CHAFING (B7-2, B7-3), BEND HEIGHT TOL. NOW 0.25 WAS 0.13 (C1-3), INCORP. DEO D-1/-2/-3	CP	14.04.01
D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-045 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.04.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D212-664-141	REV. E SHEET 1 OF 5
TITLE XTUBE ASSY (205/212/412 HI FWD)	SCALE NTS
COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



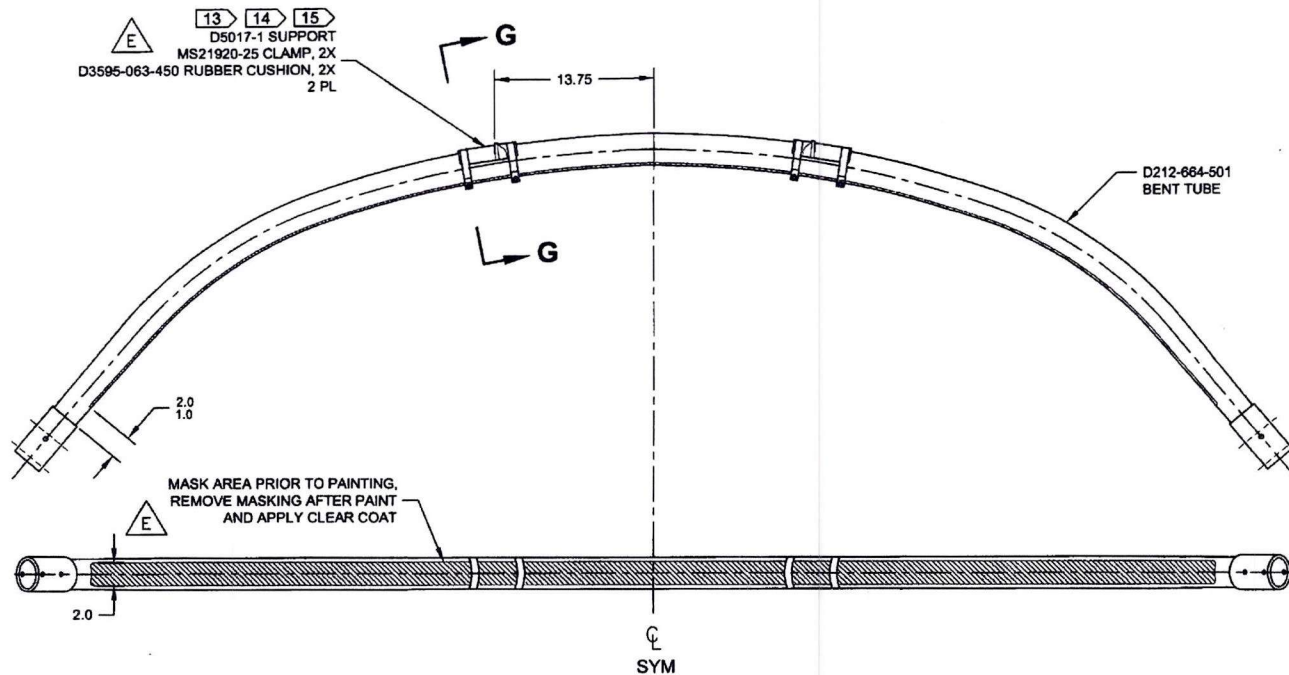
SECTION A-A
SCALE 4X

**D212-664-141/-141F
ASSEMBLY DETAIL**

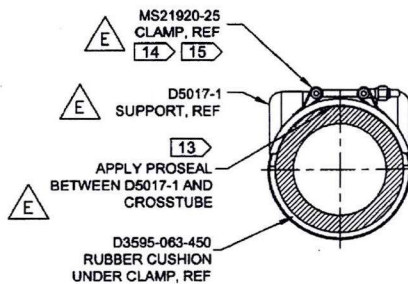
RELEASED
2014-05-26
AND

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DL	DRAWING NO.	REV. E
MFG. APPR.	DL	D212-664-141	SHEET 2 OF 5
APPROVED	DL	TITLE	SCALE
DE APPR.	DL	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
DATE	14.04.01	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



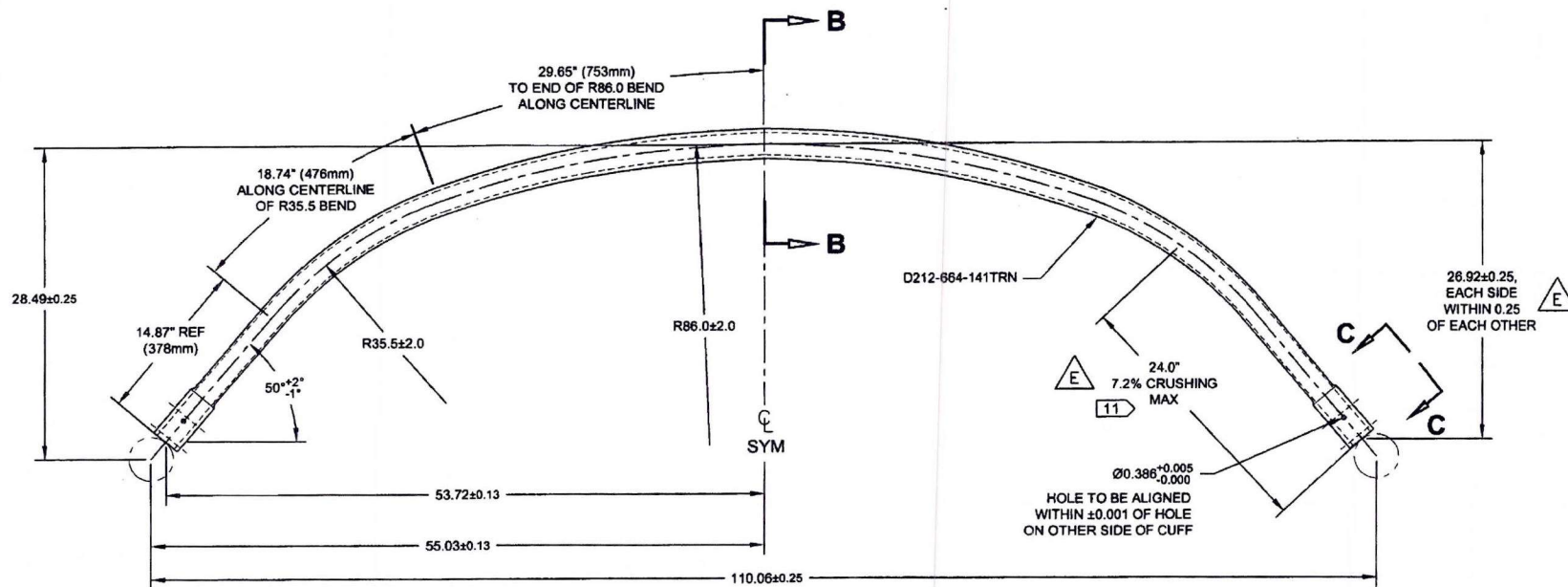
**D212-664-141B
ASSEMBLY DETAIL**



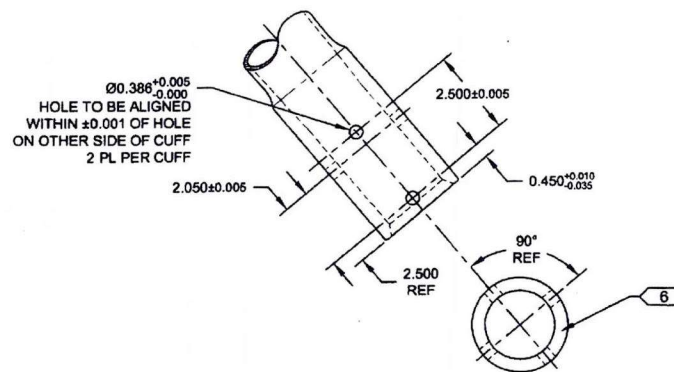
**SECTION G-G
SCALE 4X**

RELEASED
2014-05-26

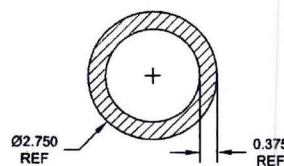
DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DW	DRAWING NO.	REV. E
MFG. APPR.		D212-664-141	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		XTUBE ASS'Y (205/212/412 HI FWD)	NTS
DATE	14.04.01	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D212-664-501
BENDING AND DRILLING DETAIL 11



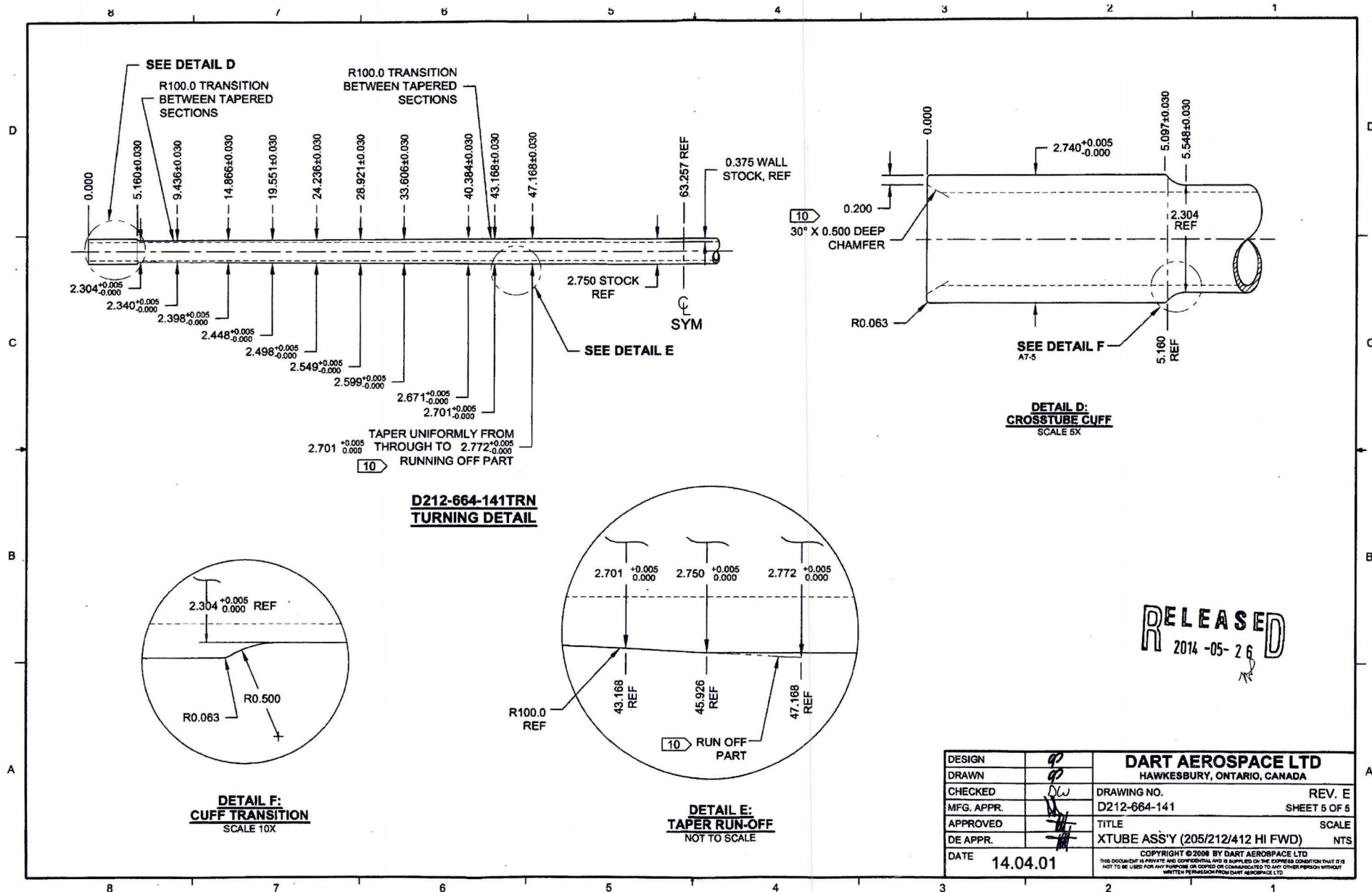
VIEW C-C: CUFF DETAIL
SCALE 3X



SECTION B-B
SCALE 4X

RELEASED
2014-05-26

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D212-664-141	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		XTUBE ASS'Y (205/212/412 HI FWD)	NTS
DATE	14.04.01	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			





Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO041148

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041148
PO Date: 9/26/18
Due Date: 9/28/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180863	D407-667-105	Fwd Crosstube - High 407 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC- 32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** OUTSIDE SERVICE -CROSSTUBES Liquid Penetrant Inspection as per QSI 038 Or Level 2 Attach copy of NDT results to work order	Firmed	-	9/28/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00
	180861	1 X	OCT 0 2 2018	Firmed	-	9/28/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00
	180864	1 X	OCT 0 2 2018	Firmed	-	10/5/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00
Sub Total:							3	0	3		\$363.00
2	182865	D212-664-101	Fwd Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA- 316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	9/28/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00
	182864	1 X	OCT 0 2 2018	Firmed	-	9/28/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00
	182867	1 X	OCT 0 2 2018	Firmed	-	9/28/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00

Plex 10/2/18 10:17 AM dart.tsimiklis.chrisoula



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO041148

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
	182866		<i>1 X</i> OCT 0 2 2018 <i>[Signature]</i>	Firmed	-	10/5/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00
Sub Total:							4	0	4		\$484.00
<i>3</i>	180148	D119-796-141	Fwd Crosstube Installation Without Step (No Hardware) : TC STC SH14-45-Issue 1, FAA STC SR03504NY 15/01/28, EASA STC 10052022 Revision 1 15/02/13, DGCA INDIA LoA 07-09/2011-AED (Part) 15/07/16, BRAZIL STC 2015S07-16 15/07/30, CAAP PHILIPPINES LoA 16/05/11, CHINA VSTC0757 16/07/22, RUSSIA STC CT316-A119 16/08/11, DGAC INDONESIA STC SR025 18/02/19 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	9/28/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00
			<i>1 X</i> OCT 0 2 2018 <i>[Signature]</i>								
<i>4</i>	182055	D130-1048-241	EC130 Aft Crosstube *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	9/28/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00
			<i>1 X</i> OCT 0 2 2018 <i>[Signature]</i>								
	182060		<i>1 X</i> OCT 0 2 2018 <i>[Signature]</i>	Firmed	-	9/28/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00
Sub Total:							2	0	2		\$242.00
Grand Total:										\$1,210.00	

DAL
38
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041148

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/2/18 10:17 AM dart.tsimiklis.chrisoula



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO37590	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO41148 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 10 CROSSTUBES

ITEM ID: D119-796-141 FWD CROSSTUBE

1 - WORK ORDER ID#: 180148 ✓

ITEM ID: D212-664-101 FWD CROSSTUBE - HIGH

2 - WORK ORDER ID#: 182866 ✓

3 - WORK ORDER ID#: 182865 ✓

4 - WORK ORDER ID#: 182864 ✓

5 - WORK ORDER ID#: 182867 ✓

ITEM ID: D130-1048-241 EC130 AFT CROSSTUBE

6 - WORK ORDER ID#: 182055 ✓

7 - WORK ORDER ID#: 182060 ✓

ITEM ID: D407-667-105 FWD CROSSTUBE - HIGH 407

8 - WORK ORDER ID#: 180861 ✓

9 - WORK ORDER ID#: 180863 ✓

10 - WORK ORDER ID#: 180864 ✓

DA
38
9-89

Action Taken:		Date:	Initial/Stamp:		
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-10) AS PER ASTM1417M-13		SEP 26 2018			
NO CRACK FOUND					
Pen: ZL-27A MWO5678 DEV: SKD-S2 MPO11715 CLEANER: SKC-S MPO13923					
Description	Location P/N	Qty	Batch	S/N Off	S/N On
N/A					

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:		ACA/SCA Stamp	Date:
Name:			SEP 26 2018

Change Record

PAGE 1 OF 1

Part Number: D212-664-101/-101MB

Description: CROSSTUBE INSTALLATION, HIGH FWD

[illegible]